

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000656**Date Inspected:** 17-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhang Xu Liang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Caltrans Mockup**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M and U-Rib Trial Assembly, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Skin Plate B	NA	NA	ZPMC MT

Mock-Up 89M, Skin Plate B: Caltrans QA Inspector witnessed ZPMC Quality Control inspector, Mr. Cai Xin Xin perform magnetic particle test (MT) and Visual Test (VT) inspection at partial joint penetration (PJP), butt weld cover pass. ZPMC MT coverage appeared to be 100 percent of the weld. The location is identified as skin plate splice weld, mp505 to MA24 weld number 5. The MT appeared to be in compliance with the project specification and found to be in compliant by QC.

Caltrans QA Inspector performed MT and VT inspection of the weld 5 cover pass weld. See Caltrans Magnetic Particle Test Report, TL6028, generated on this date for additional information.

2	Skin Plate D (upper)	NA	NA	ZPMC MT
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Mock-Up 89M, Skin Plate D (upper): Caltrans QA Inspector witnessed ZPMC Quality Control inspector, Mr. Zhou Dongyun perform magnetic particle test (MT) and Visual Test (VT) inspection at the partial joint penetration (PJP) and complete joint penetration (CJP) butt weld cover pass and eight attachment (lifting aid) removal locations. ZPMC MT coverage appeared to be 100 percent of the welds and attachment removal locations. The weld locations are identified as skin plate splice weld, mp509 to mp513 welds outside/inside side. The MT appeared to be in compliance with the project specification and found to be in compliant by QC.

Caltrans QA Inspector performed MT and VT inspection of the PJP, CJP and attachment removal locations. See

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Caltrans Magnetic Particle Test Report, TL6028, generated on this date for additional information. Following digital picture illustrates ZPMC MT in progress.



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|---|----------------------|----|----|---------|
| 3 | Skin Plate D (lower) | NA | NA | ZPMC MT |
|---|----------------------|----|----|---------|

Mock-Up 89M, Skin Plate D (lower): Caltrans QA Inspector witnessed ZPMC Quality Control inspector, Mr. Cai Xin perform magnetic particle test (MT) and Visual Test (VT) inspection at the partial joint penetration (PJP) and complete joint penetration (CJP) butt weld cover pass and eight attachment (lifting aid) removal locations. ZPMC MT coverage appeared to be 100 percent of the welds and attachment removal locations. The weld locations are identified as skin plate splice weld, mp506 to MA 22 welds outside/inside side. The MT appeared to be in compliance with the project specification and found to be in compliant by QC.

Caltrans QA Inspector performed MT and VT inspection of the PJP, CJP and attachment removal locations. See Caltrans Magnetic Particle Test Report, TL6028, generated on this date for additional information. Following digital picture illustrates ZPMC MT in progress.



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|---|--------------|----|----|---------|
| 4 | Skin Plate E | NA | NA | ZPMC MT |
|---|--------------|----|----|---------|

Mock-Up 89M, Skin Plate E: Caltrans QA Inspector witnessed ZPMC Quality Control inspector, Mr. Zhou Dongyun perform magnetic particle test (MT) and Visual Test (VT) inspection at the partial joint penetration (PJP) butt weld cover pass and four attachment (lifting aid) removal locations. ZPMC MT coverage appeared to be 100 percent of the welds and attachment removal locations. The weld locations are identified as skin plate splice weld, mp502 to MA 38 welds outside/inside side. The MT appeared to be in compliance with the project specification and found to be in compliant by QC.

Caltrans QA Inspector performed MT and VT inspection of the PJP, CJP and attachment removal locations. See

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Caltrans Magnetic Particle Test Report, TL6028, generated on this date for additional information.

Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
